

79074

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 19/01/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 02/02/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 12/01/19

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

100			0.00		
100					
Mill Conv	Memo		0.00	12/01/25	10
Conventional Milling Machine	1-mill as per Dwg D4407				
	2-Deburr if necessary				
110			0.00		
110					
QC	Memo		0.00	5/26/25	(+10)
Quality Control	QC5- Inspect part completeness to step on W/O				
150			0.00		
150					
Packaging	Identify as per dwg & Stock Location: <u>W/A</u>		0.00		
Packaging	Memo		0.00	12-7-2	(KB)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79074***79074***

Page 2

January-19-12 1:39:18 PM

Item ID: D4407-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar

Start Date: 19/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

M.C.J. 12/02/03 P/2028
(10)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-19-12 1:39:22 PM

Page 1

Work Order ID: 79074

79074

Parent Item: D4407-3

D4407-3

Parent Item Name: Bar

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 11.06.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	669.4167	4.8	50.52632			

M304B0 250x0 500

304 BAR .250 x .500

Location	Loc Qty	Loc Code
MAT006	256.122	
117842	8.3	
119050	21.67	
119159	226.152	
MAT050	413.2947	
117176	37.8947	
119872	375.4	

52. ~~12~~ 12/01/25

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

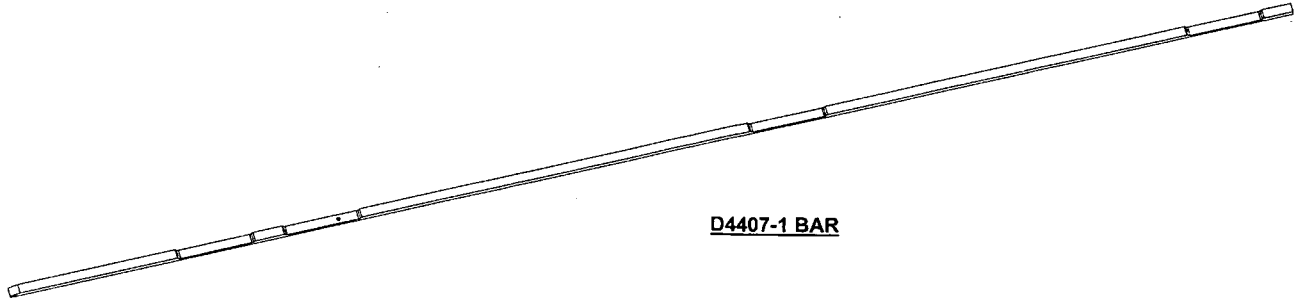
D

C

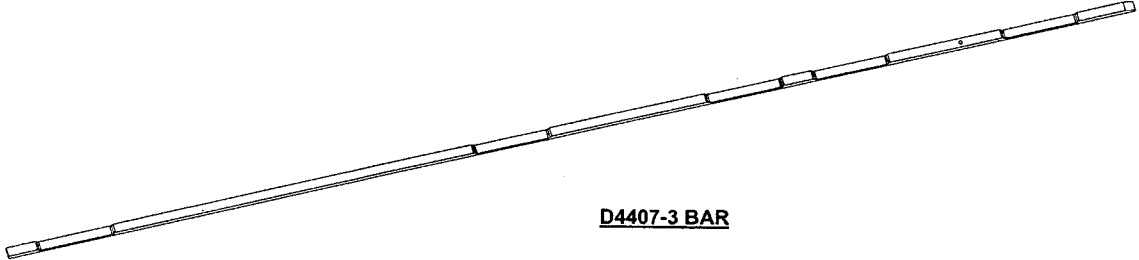
B

A

8 7 6 5 4 3 2 1



D4407-1 BAR



D4407-3 BAR

UNCC
SUB
W
V
NO. 79074 H.C.S
12/01/19

RELEASE
R 2011-08-29
WIP

A	NEW ISSUE	RF	11.08.15
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4407	SHEET 1 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BAR	NTS
DATE	11.08.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

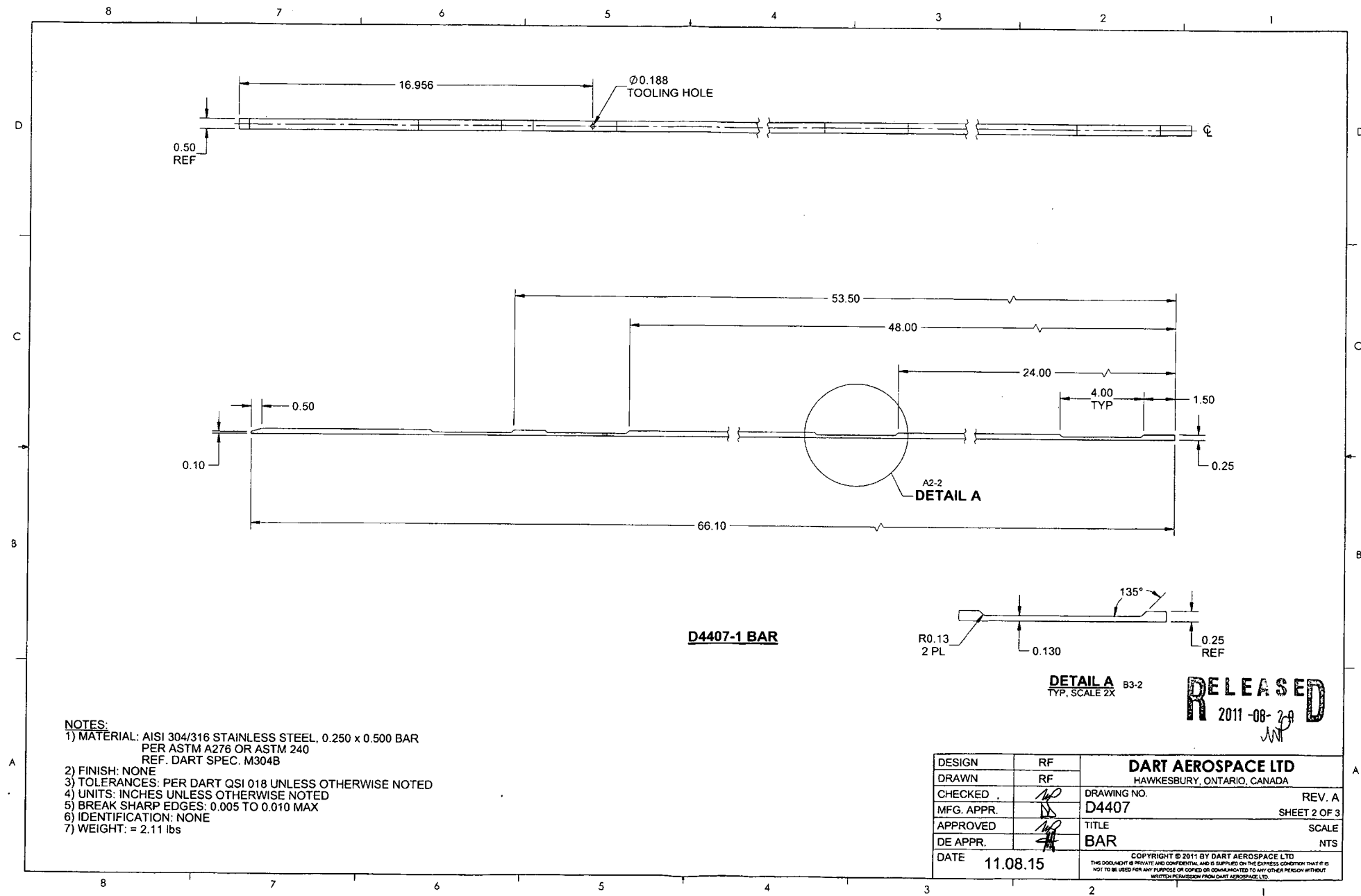
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

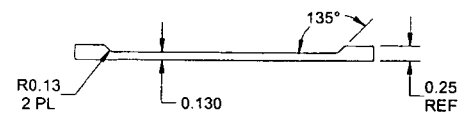
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79074



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: = 2.11 lbs



DETAIL A B3-2
TYP. SCALE 2X

RELEASED
2011-08-29

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4407	SHEET 2 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	BAR	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

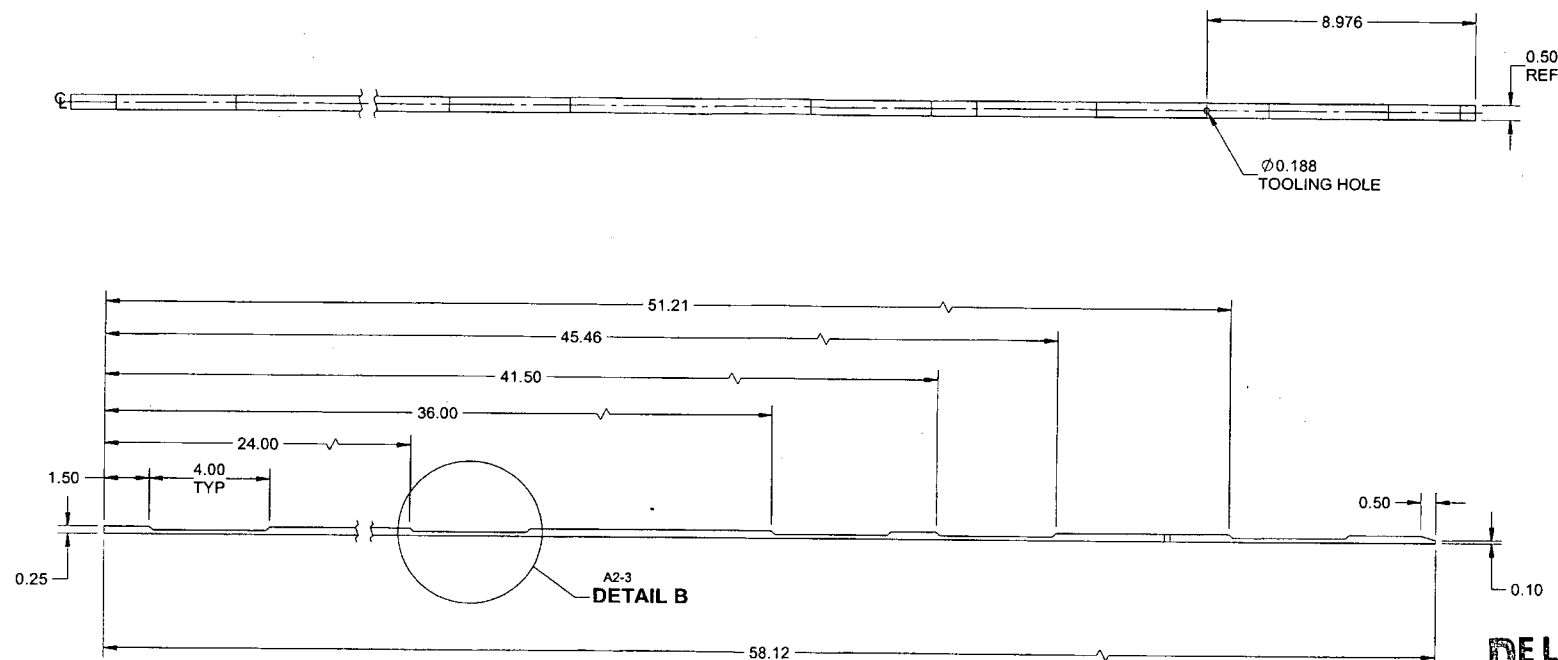
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

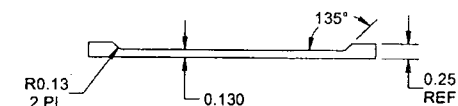
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79074



D4407-3 BAR



DETAIL B B5-3
TYP, SCALE 2X

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL, 0.250 x 0.500 BAR
PER ASTM A276 OR ASTM 240
REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: = 1.76 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4407	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAR	NTS
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

Description: BAC		Part Number: 4407-3	Page 1 of 1
Work Order: 79074		Inspection Dwg: 4407 Rev: A	

☒ First Article ☐ Prototype

Drawing	Dimension	Tolerance	Actual	Dimension	Accept	Reject	Method of Inspection	Comments
1.50	±.030	1.50	—	—	—	—	RA04	Tape
4.00	±.030	4.00	—	—	—	—	"	"
24.00	±.030	24.00	—	—	—	—	"	"
36.00	±.030	36.00	—	—	—	—	RA04	"
41.50	±.030	41.50	—	—	—	—	"	"
45.46	±.030	45.46	—	—	—	—	"	"
51.21	±.030	51.21	—	—	—	—	"	"
50	±.030	50	—	—	—	—	RA04	Tape
110	±.030	110	—	—	—	—	RA26	Vern
1130	±.010	1132	—	—	—	—	RA26	Vern

Measured by: <i>[Signature]</i>	Date: 2/01/25	Audited by: <i>[Signature]</i>	Date: 12/01/25	Prototype Approval: _____	Date: _____
Rev	Date	Change	Revised by	KJ/MLM	Approved

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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